

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028422**Date Inspected:** 14-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job site**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Rodney Patterson was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**Ultrasonic Testing OBG**

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) Corner drop-in stiffener connections for lifts 12E, 12W. The weld was previously tested and accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QAI's findings are as follows;

**Lift 12E Corner Longitudinal Deck Stiffener (Weld No. 12E/13E-LS2)**

The QAI performed a verification in way of repairs Y=210 previously rejected by the QAI on 09-06-2012. No rejectable indications were observed at the time of inspection.

**Lift 12W Corner Longitudinal Deck Stiffener (Weld No. 12W-PP111.1-LS3)**

The QAI performed a minimum of 10% verification of this weld. No rejectable indications were observed at the time of inspection.

**QA Recordable Verification**

The QAI was provided by the QA Task Leader, a list of recordable indications transferred from the QC final ultrasonic Testing reports to verify. The transverse deck splice for the corner drop-in for lift 12W was ultrasonically examined in way of the Y locations that recordable indications were noted on the QC ultrasonic test

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reports. The QAI's findings on the verification of recordable indications are as follows.

### Weld 12W/13W-A1.1

Y=325, AWS db rating=+12 was observed and recordable indication confirmed

Y=375, AWS db rating=+14 was observed and recordable indication confirmed

Y=400, AWS db rating=+17 was observed and recordable indication confirmed

Y=435, AWS db rating=+14 was observed and recordable indication confirmed

Y=560, Unable to detect a recordable indication at this Y location.

Y=640, AWS db rating=+11 was observed and recordable indication confirmed

Y=695, AWS db rating=+12 was observed and recordable indication confirmed

Y=765, AWS db rating=+13 was observed and recordable indication confirmed

Y=1290, AWS db rating=+17 was observed and recordable indication confirmed

Y=1390, AWS db rating=+17 was observed and recordable indication confirmed

Y=2025, AWS db rating=+18 was observed and recordable indication confirmed

### Weld 12W-PP111.1-A1

Y=425, AWS db rating=+18 was observed and recordable indication confirmed

Y=465, AWS db rating=+19 was observed and recordable indication confirmed

Y=610, AWS db rating=+16 was observed and recordable indication confirmed

The QAI spent a portion of this shift reviewing and documenting the status and completion of various production welding tracking logs for lift 13E-14E drop-in deck work currently in-process. The QA recorded the information on the OBG tracking log.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

As noted above

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patterson,Rodney
<b>Reviewed By:</b>	Levell,Bill

Quality Assurance Inspector

QA Reviewer